

Work Order ID 73090

Thursday, August 25, 2011 1:26:51 PM



Page 1

Item ID: D3298-007

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 8/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-08-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3298

Rev A2

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Bend tube as per template D3298-007T1 & Dwg D3298 Flare end as per Dwg D3298. Ensure that sleeves and coupling are installed first

SB 11/09/21

(4)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 w/ 11/21

(4)

120

0.00



Identify as per dwg & Stock Location: *195*

Packaging

Memo

0.00

Packaging

11/9/22 (4) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 1:26:47 PM

Page 1

Work Order ID: 73090

Parent Item: D3298-007

Parent Item Name: Tube Assembly




Start Date: 8/25/2011

Required Date: 9/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.09.02 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status												
AN818-6D  Nut		Purchased	No			100	Each	16.0000	2	8															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST331</td><td>16</td><td></td></tr><tr><td>114988</td><td>16</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST331	16		114988	16				
Location	Loc Qty	Loc Code																							
ST331	16																								
114988	16																								
M6061T6T0.375W.035  6061-T6 RD Tube .375 x.035W		Purchased	No			100	f	220.5100	0.6666	2.806737															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>MAT014</td><td>220.51</td><td></td></tr><tr><td>104913</td><td>31.75</td><td></td></tr><tr><td>112652</td><td>188.76</td><td></td></tr></table>														Location	Loc Qty	Loc Code	MAT014	220.51		104913	31.75		112652	188.76	
Location	Loc Qty	Loc Code																							
MAT014	220.51																								
104913	31.75																								
112652	188.76																								
MS20819-6D  Sleeve		Purchased	No			100	Each	24.0000	2	8															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST323</td><td>24</td><td></td></tr><tr><td>116289</td><td>24</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST323	24		116289	24				
Location	Loc Qty	Loc Code																							
ST323	24																								
116289	24																								

SB 11/09/21

18

SB 11/09/21

3

3

SB 11/09/21

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

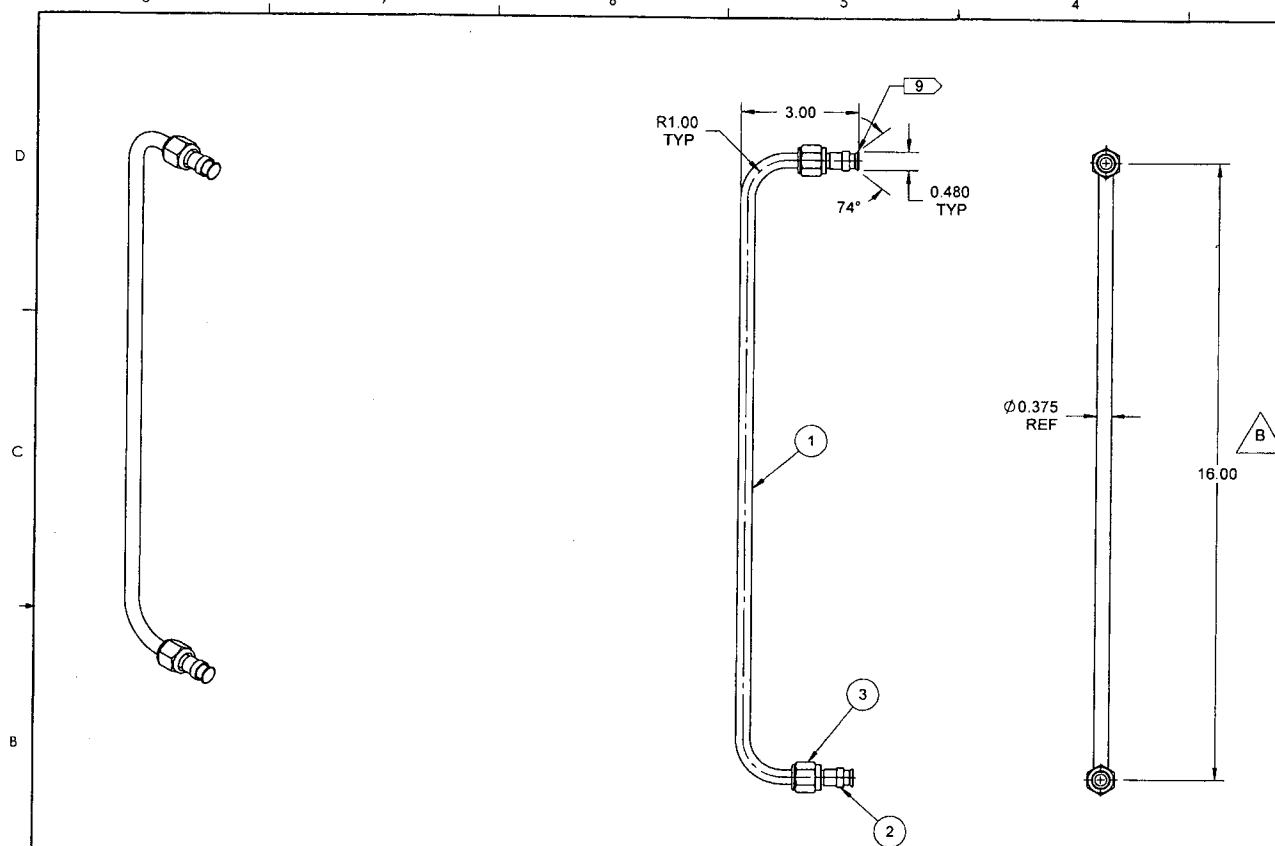
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY -001	P/N	DESCRIPTION
1	X	D3298-001	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-001 TUBE ASSEMBLY

73090

RELEASED
R 2010-01-14
[Signature]

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

B	DRAWING UPDATED TO CURRENT STANDARDS. 16.00 WAS 15.75 (ZN C3-1, C4-2) & CORRECT VIEW (ZN D4-2). PER CAR 09-004	RF	09.12.30
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3298 TITLE TUBE ASSEMBLIES REV. B SHEET 1 OF 8 SCALE NTS <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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DE APPR.	<i>[Signature]</i>		
DATE	09.12.30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

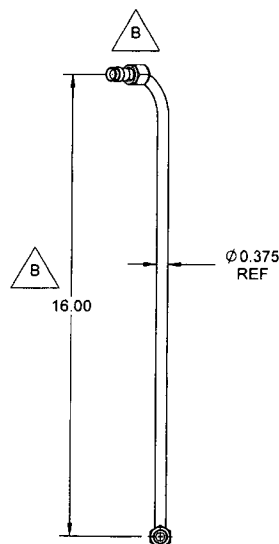
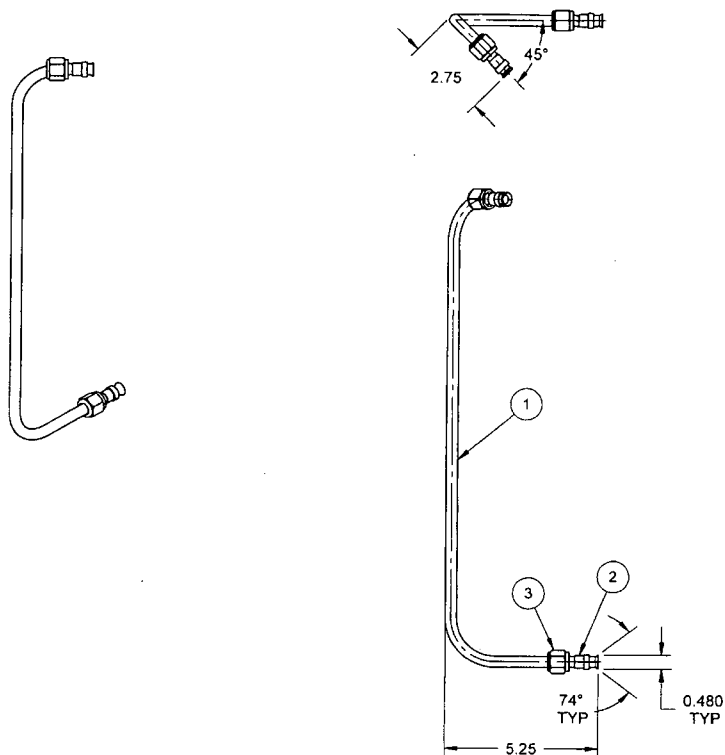
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -003	P/N	DESCRIPTION
1	X	D3298-003	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-003 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-003T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

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MFG. APPR.	<i>[Signature]</i>	D3298	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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473090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

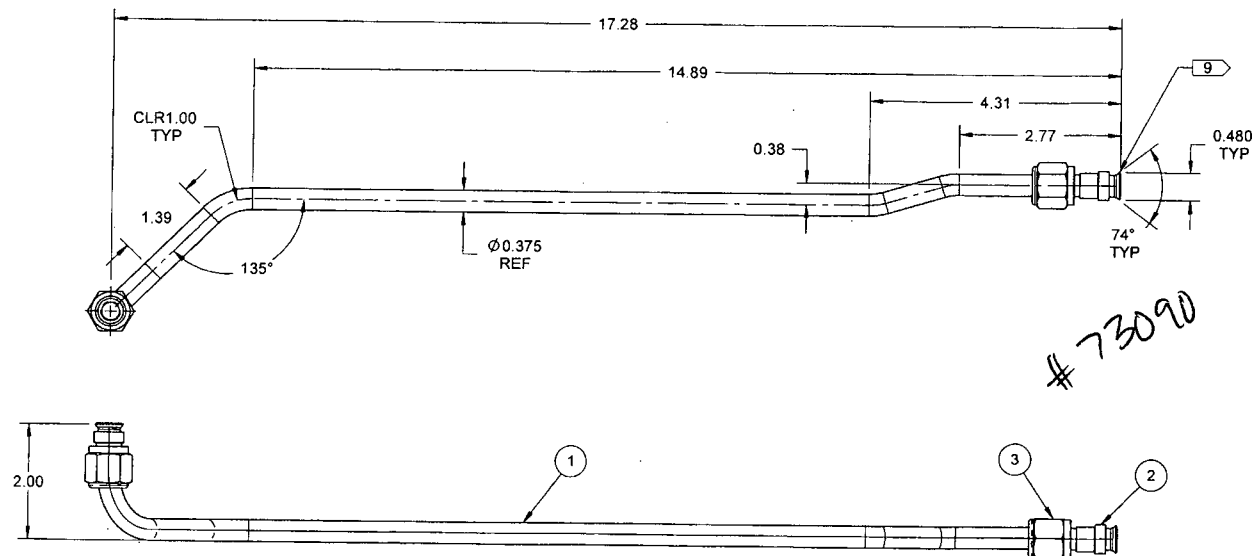
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -005	P/N	DESCRIPTION
1	X	D3298-005	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-005" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-005T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

D3298-005 TUBE ASSEMBLY

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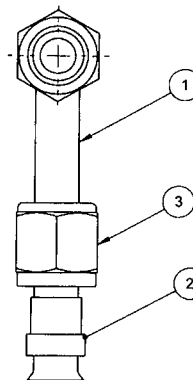
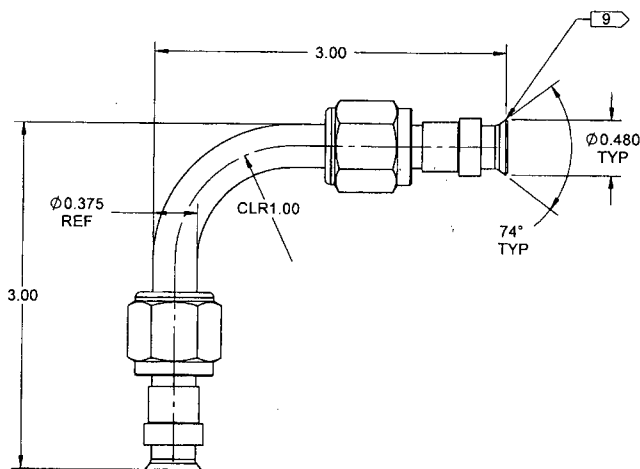
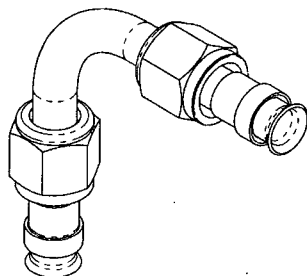
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
1	X	D3298-007	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-007" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-007T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

D3298-007 TUBE ASSEMBLY

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2010-01-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

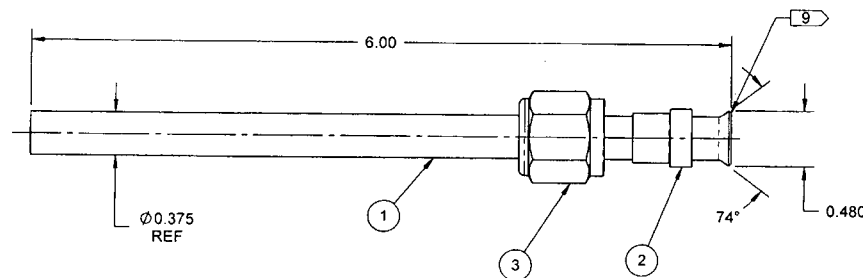
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .009	P/N	DESCRIPTION
1	X	D3298-009	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



D3298-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-16

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3298	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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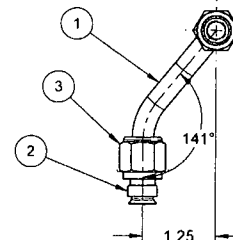
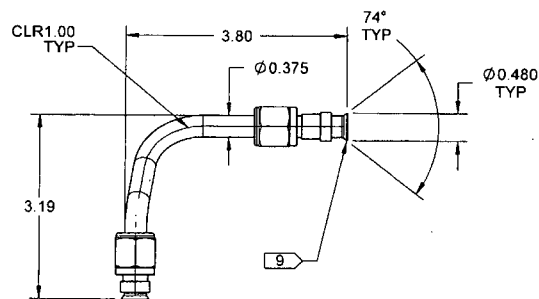
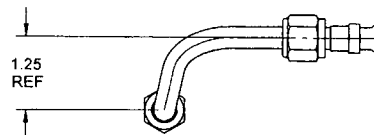
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3298-011	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



73040

D3298-011 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-011" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-011T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
R 2010-01-14

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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3298	SHEET 6 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
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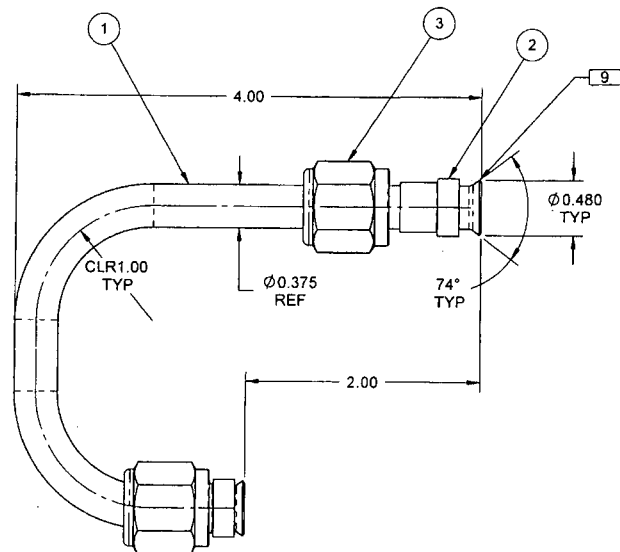
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3298-013	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-013 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-013" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-013T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS. TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
MD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3298	REV. B
MFG. APPR.	RF	SHEET 7 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
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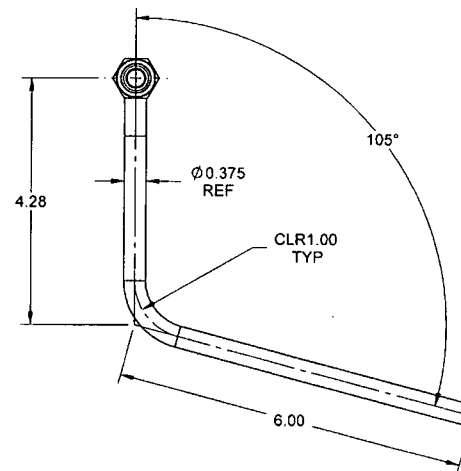
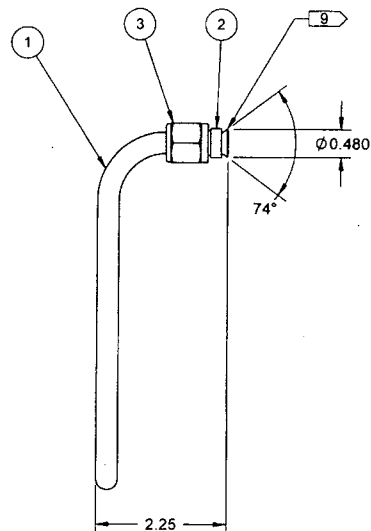
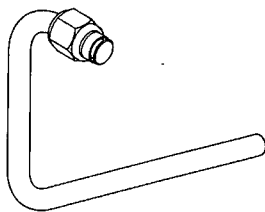
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -015	P/N	DESCRIPTION
1	X	D3298-015	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



73090

D3298-015 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-015" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-015T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2018-01-14

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3298	SHEET 8 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
DATE	09.12.30	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries